

Ship 78/00

5

Date: Tuesday, 1/8/2008 1:18:18 PM  
User: Kim Johnston

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	206L BASKET LID		
Job Number	36654B					
Estimate Number	11274					
P.O. Number	:		Part Number	D2252043		
This Issue	: 1/8/2008	S.O. No. :	Drawing Number	D2252 REV E		
Prshf Rev.	: NC		Project Number	N/A		
First Issue	: / /	Type : LARGE FAB ASSY	Drawing Revision	E		
Previous Run	: 35657B		Material	:		
Written By	:	108.01.08	Due Date	: 1/31/2008	Qty:	1 Um: Each
Checked & Approved By						
Comment	Est Rev	REVISED AS PER REV E 05-12-06	JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	
		Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s) 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: <u>M108063</u>	 SA0 08/06/11 (1)
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1- Cut D2252-1-3-9 as per Dwg D2252	
		2- Drill hole in D2252-1 as per Dwg D2252	
		3- Deburr & Remove all Markings from Material	 SA0 08/06/11 (1)
3.0	D2329	Label Plate	 FC 08 06 12
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	
		1 D2329 Label Plate <u>135686</u>	
4.0	D23271	Spacer Bushing	 FC 08 06 12
		Comment: Qty.: 1.0000 Each(s)/Unit Total.: 1.0000 Each(s) Pick: Qty Part Number Description Batch	
		1 D2327-1 Bushing <u>136920</u>	

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES				
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
2023-04-20	1	SOURCE DOCUMENTATION CONCERNING THE DESIGN OF THE AIRCRAFT IS NOT UP TO DATE.						
2023-04-20	2	CONCERNING THE DESIGN OF THE AIRCRAFT IS NOT UP TO DATE.						

NOTE: Date & initial all entries

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Job Number: 36654B		Part Number: D2252043
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D22321	Hinge 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2232-1 HINGE <u>B38684</u>		FC 08 06 13
6.0	D2581	Mounting Bracket 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Pick: Qty Part Number Description Batch 2 D2581 Mounting Chanel <u>039046</u>		FC 08 06 13
7.0	M304EX07516F	Expanded Metal Flat Stai 
Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s) Pick: Qty Part Number Description Batch 18 sf M304EX0.75-16F Expanded Metal <u>M107966</u>		FC 08 06 13
8.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1 
Comment: LARGE FABRICATION RESOURCE 1  1-Weld as per Dwg D2252 using Welding Table and corner Jig Deburr as required A/R SS ROD Batch: <u>M105524 FC</u> <u>M107051 SF</u>		<u>SF</u> 08/06/12 FC 08 06 12
9.0	QC9	VISUAL WELDING INSPECTION 
Comment: VISUAL WELDING INSPECTION		<u>PD</u> 08-06-16
10.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		<u>S</u> 08/06/16 <u>(R)</u> <u>(P)</u>
11.0	POWDER COATING	POWDER COATING  <u>m107925</u>
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		<u>WB/Fd</u> 08/06/17 <u>(R)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/06/17	11.0	<p><u>1st Coat</u>            Start time: 7:40            Temperature: 400°            Finish time: 8:10</p> <p><u>2nd Coat</u>            8:25            400°            8:55</p>	FJ DW	08/06/17	U	✓	08/06/17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 206L BASKET LID

Job Number: 36654B

Part Number: D2252043

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G4

*1/8/08/06/17 C*

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/06/19 JH*

Job Completion



*U O 8-06-18*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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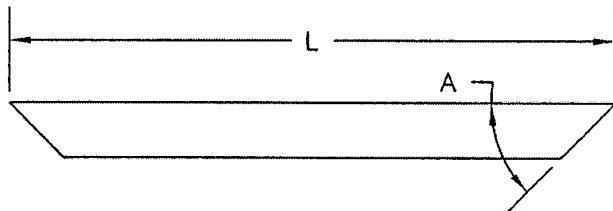
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CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2252	REV. E	SHEET 1 OF 5
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)			SCALE NTS
C	95.12.11	RE-DRAWN		
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3		
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19		

**RELEASED**  
05.11.26 *[initials]*

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
2		D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50	45
2		D2252-3	FRAME	96.00	45
	2	D2252-7	FRAME	24.00	90
1		D2252-9	FRAME	10.25	90
1		D2252-11	FRAME	25.00	90
1		D2252-13	FRAME	42.00	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78	53
2		D2252-19	FRAME	95.27	45
2		D2252-21	FRAME	30.82	90
1		D2252-23	FRAME	30.62	90
2		D2253-1	LUG		
2		D2254	GUSSET		
1		D2327-1	BUSHING		
1		D2327-3	BUSHING		
1		D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE  
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



CUT SIZE DETAIL

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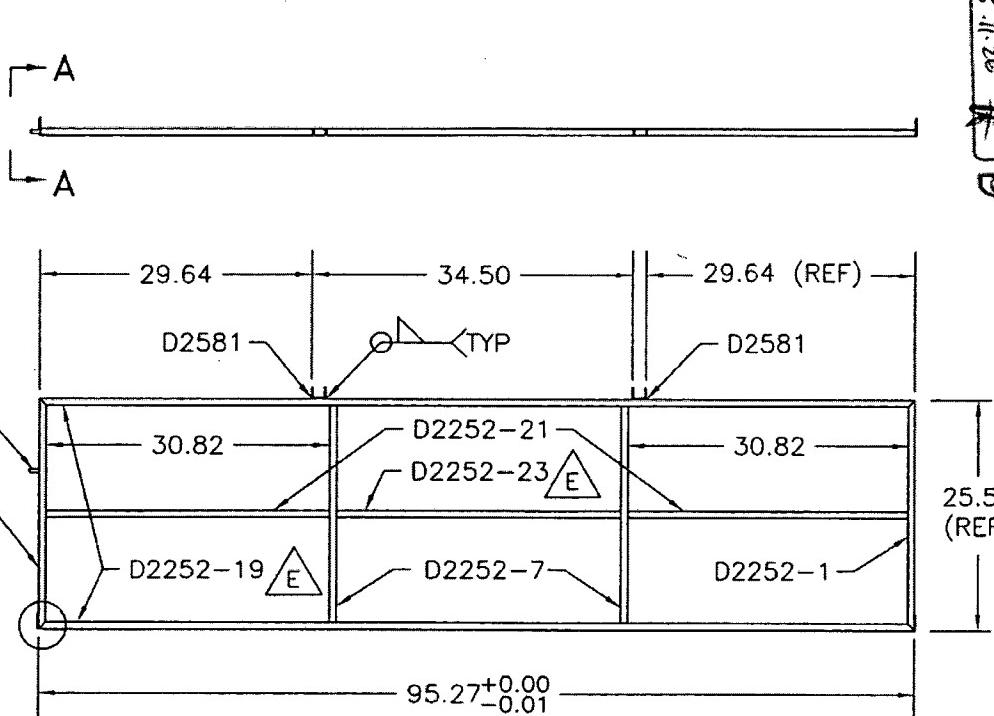
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)	SHEET 2 OF 5 REV. E SCALE NTS



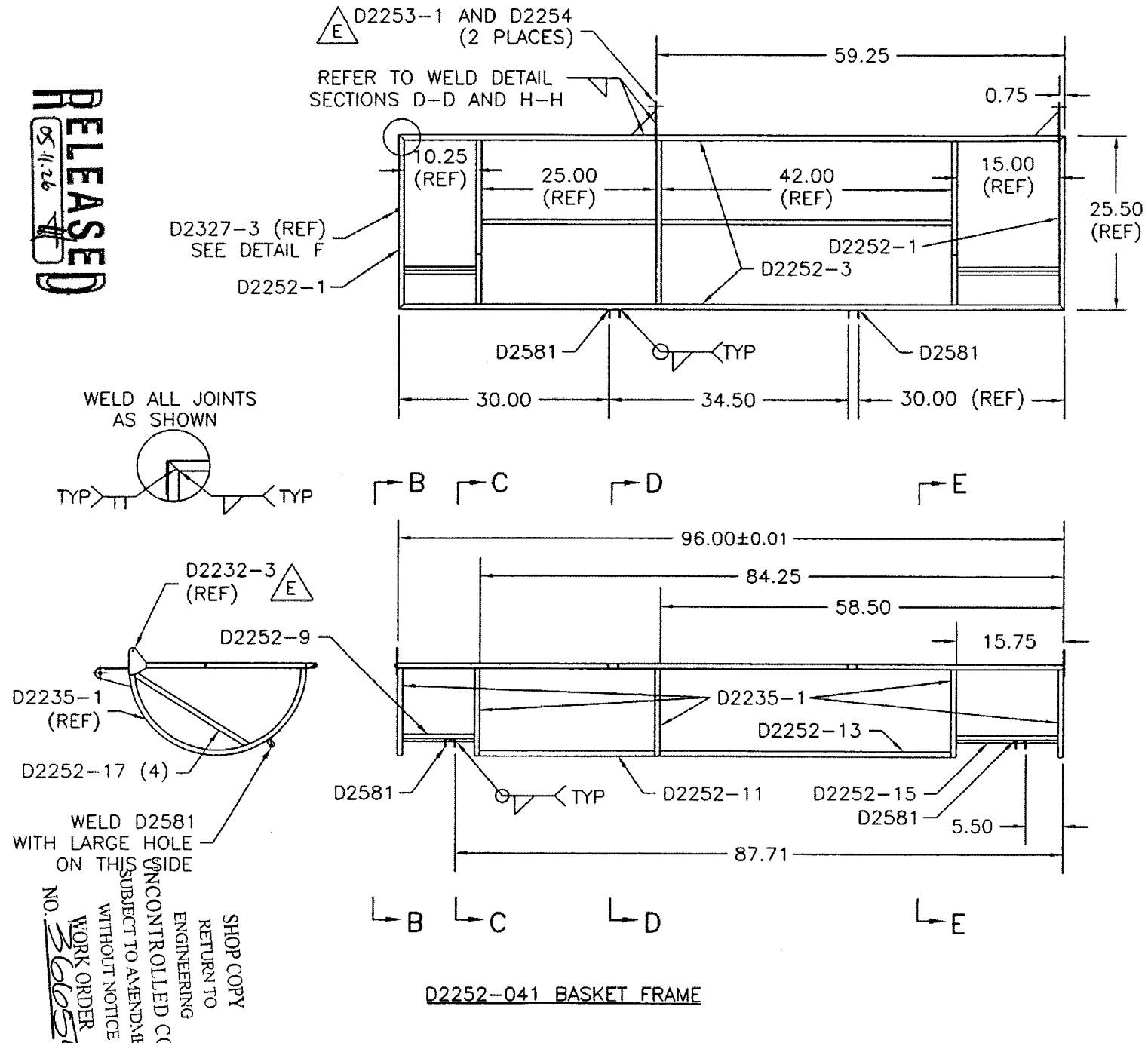
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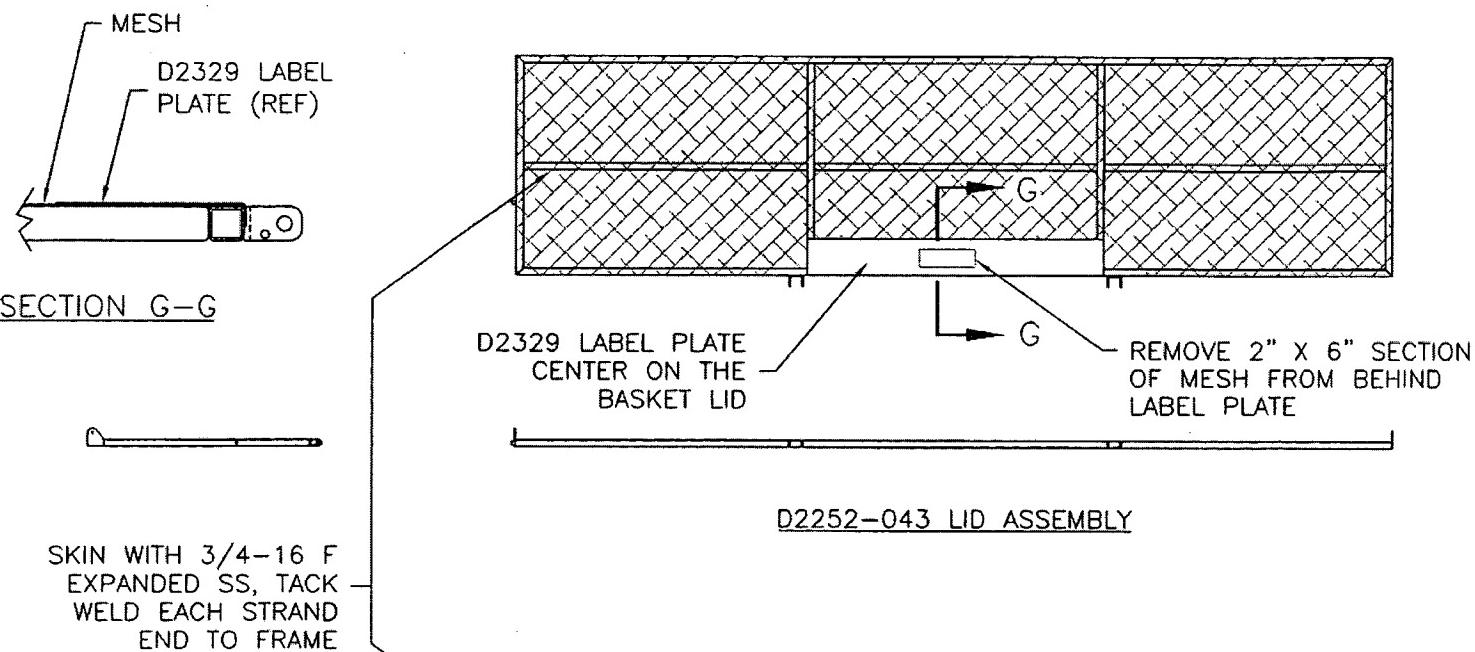


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		D2252
DATE		TITLE
05.11.10		BASKET ASSEMBLY (206L)
		SHEET 3 OF 5
		REV. E
		SCALE
		MTS

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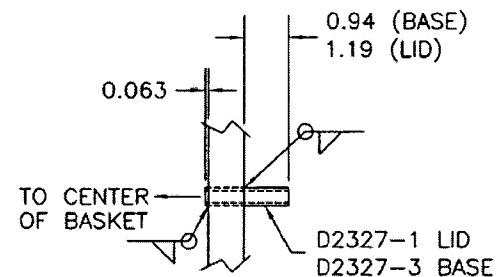
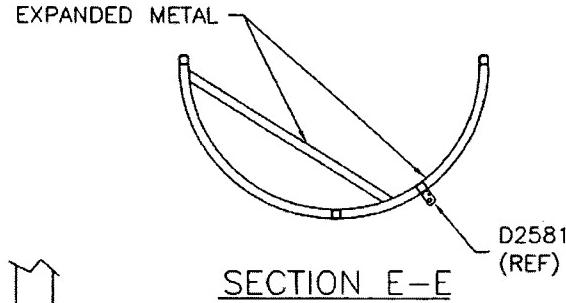
D2252-041 BASKET ASSEMBLY

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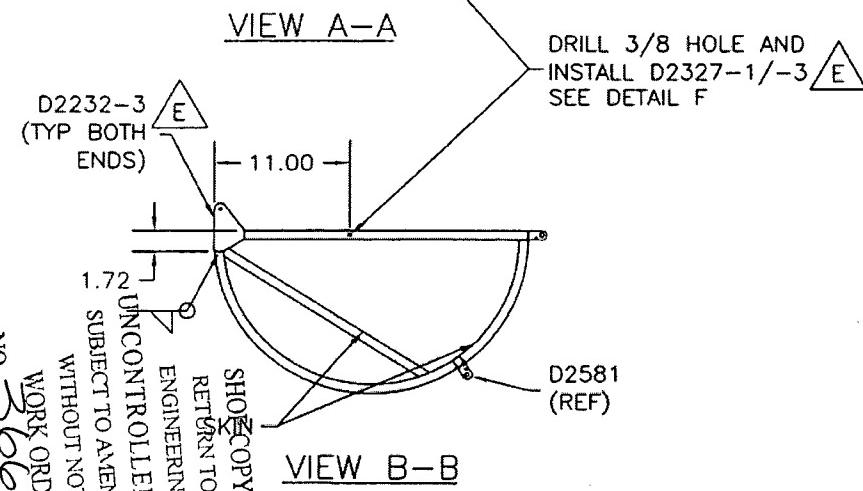
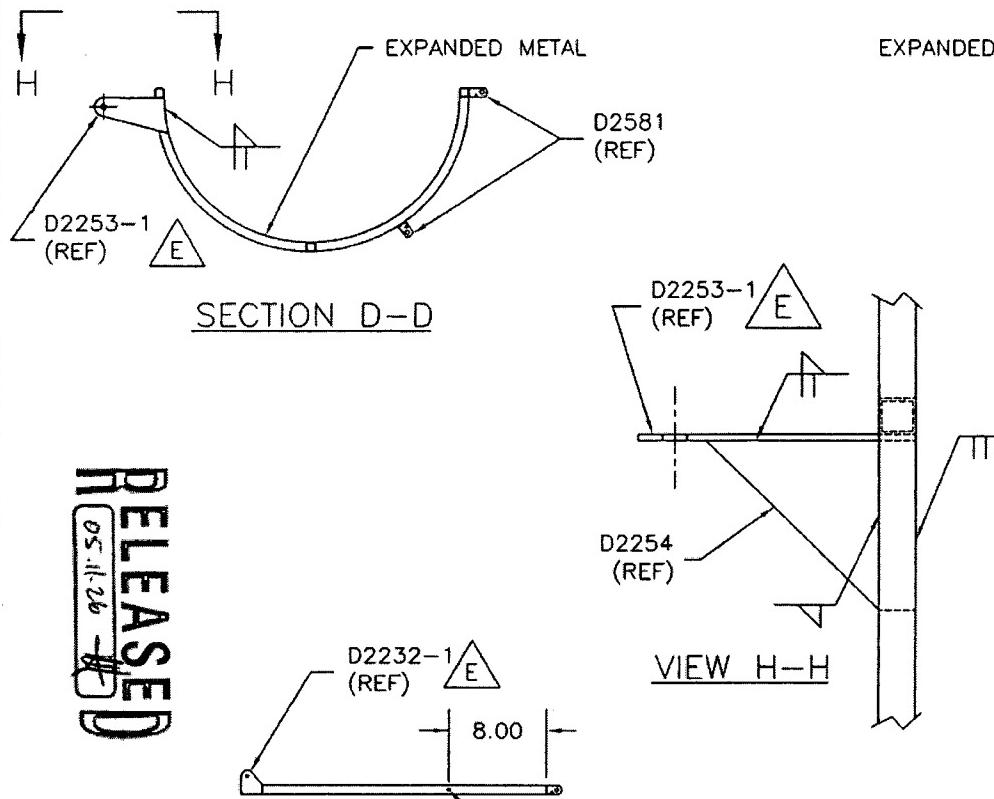
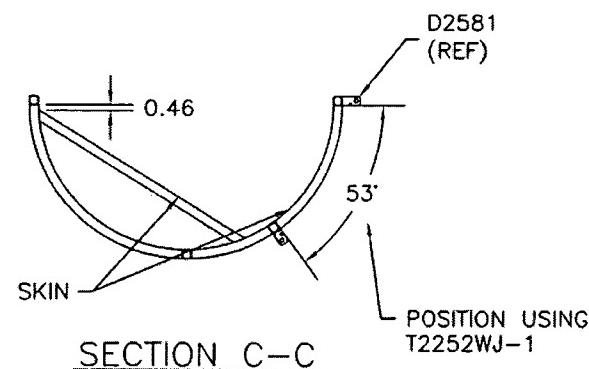
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TITLE BASKET ASSEMBLY (206L)	SCALE N/A	REVISIONS	NOTES



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